

Claims

1. A method of producing a metallic shaped part, in particular a vehicle body part, from a semifinished product made of an unhardened hot-workable steel sheet, comprising the following method steps:

- a part blank (10) is formed from the semifinished product (2) by a cold-forming method, in particular a drawing method (process step II);
- the part blank (10) is trimmed at the margins to a marginal contour (12') approximately corresponding to the part (1) to be produced (process step III);
- the trimmed part blank (17) is heated and press-hardened in a hot-forming tool (23) (process step IV).

2. The method as claimed in claim 1, characterized in that a deep-drawing method is used for shaping the part blank (10) from the semifinished product (2).

3. The method as claimed in claim 1 or 2, characterized in that the part blank (10) is trimmed by means of a mechanical cutting method (15).

4. The method as claimed in claim 3, characterized in that the trimming of the part blank (10) is effected as part of the cold forming.

5. The method as claimed in one of the preceding claims, characterized in that the tool (23) is cooled with a brine.

6. The method as claimed in one of the preceding claims, characterized in that the semifinished product (2) is made of an air-hardened steel alloy.

7. The method as claimed in the preceding claims, characterized in that the heating and hot forming of the trimmed part blank (17) are effected in an inert-gas atmosphere (26).

8. The method as claimed in claim 7, characterized in that

- the part (1) is cooled after the hot forming (process step IV) down to a temperature below the martensite temperature
- and is provided immediately afterward with a surface coating, in particular an anti-corrosion coating.

9. The method as claimed in the preceding claims, characterized in that the heating of the trimmed part blank (17) in process step IV is effected in a continuous furnace (21).

10. The method as claimed in one of claims 1 to 8, characterized in that the heating of the trimmed part blank (17) in process step IV is effected inductively.